

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003500**Date Inspected:** 04-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2130**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Zu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Orthotropic Box Girder (OBG) Fabrication:

New OBG Assembly Shop

The QA Inspector performed ultrasonic inspections of approximately 10% length of Assembly plate SEG024A complete joint penetration (CJP) groove welds -001 (between SP305A and SP332A), -002 (between SP359A and SP332A), -003 (between bp57A and bp111A) and -004 (between BP57A and BP165A). ZPMC had previously documented they have performed and accepted UT inspections of these same welds. See the TL-6027 "Ultrasonic Test Report" dated today and the photograph below for additional information.

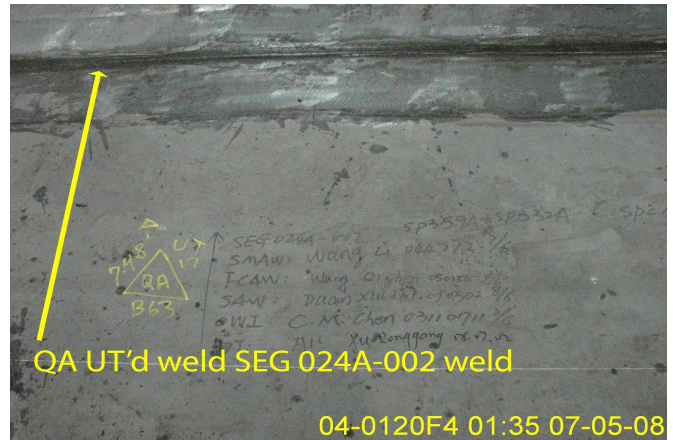
ZPMC "Notification of witness inspection documents #0618 and #0619 states welds SEG015A-007, SEG015A-008, and FB012-010-045 are to have been UT inspected earlier today. The QA Inspector along with ZPMC QC CWI Inspector Mr. Zu Jun were not able to locate these welds in the New OBG Assembly Shop this shift.

Heavy Shop 1

WELDING INSPECTION REPORT

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ZPMC "Notification of witness inspection" document 0623 states welds SSD1 SA178 C/D-24, SEG015A-007, SEG015A-008, and FB012-010-045 are to be UT inspected by ZPMC personnel today. The QA Inspector along with ZPMC QC CWI Inspector Mr. Zu Jun were not able to locate these welds in the New OBG Assembly Shop this shift and no determination could be made to ascertain if these welds are ready for QA ultrasonic inspections.



Summary of Conversations:

No significant conversations occurred.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
